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D3043-041

Job Sheet 181787



Part No: D3043-041

Job Qty: 2 ea

Part Name: Step Weldment LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		9/7/18	0.00	0.00	Start Up Large Fab-4		SLY
100	Large Fab	2 pcs		9/7/18	0.00	2.64	Large Fab 8		SAS
110	QC	2 pcs		9/7/18	0.00	0.00	QC6		38
120	Large Fab	2 pcs		9/7/18	0.00	2.64	Large Fab 8		9-89 SLY
130	QC	2 pcs		9/7/18	0.00	0.00	QC9		CPC
140	QC	2 pcs		9/7/18	0.00	0.00	QC5		CPC
150	HandFinish	2 pcs		9/7/18	0.00	0.50	HandFinish1		D.R. 18/09/26
160	Large Fab	2 pcs		9/7/18	0.00	2.64	Large Fab 8		DAS
170	QC	2 pcs		9/7/18	0.00	0.00	QC10		38
180	QC	2 pcs		9/7/18	0.00	0.00	QC5		9-89 38
200	HandFinish	2 pcs		9/7/18	0.00	0.50	HandFinish6		D.R. 18/10/1
210	Powdercoat	2 pcs		9/7/18	0.00	0.58	Powdercoat1		18-10-3
220	HandFinish	2 pcs		9/7/18	0.00	0.50	HandFinish3		BER 18-10-3
230	QC	2 pcs		9/7/18	0.00	0.00	QC3		OCT 09 2018 68
240	Packaging	2 pcs		9/7/18	0.00	0.00	Packaging3-1		6
250	QC21-SA	2 Ea		9/7/18	0.00	0.00	QC21		9-89 38

Part Op 100 - 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G 2-Debur and Descriptions: bevel ends for welding

120 - 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802 AR AL ROD

Batch: M134785 2-Grind Fwd End Cap weld flush

160 - 1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: M134785 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush

210 - START TIME: 11:30 OVEN TEMPERATURE: 320° FINISH TIME: 12/10.

Wing work 5098120

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	5104007
D3040-3	Mounting Lug	4 Ea (2 ea)	90-Start up Operation	128957
D2734	Step End Plate	2 Ea (1 ea)	120-Large Fab	5077383
D3040-1	Mounting Lug	4 Ea (2 ea)	120-Large Fab	5106291
D2734	Step End Plate	2 Ea (1 ea)	160-Large Fab	5077383

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	3	0
	D3040-3	4	18	0
120-Large Fab	D2734	2	34	0
	D3040-1	4	2	0
160-Large Fab	D2734	2	34	0
Part Specifications				
Specifications could not be found.				

Plex 8/9/18 7:59 AM Dart.lajeunesse.marie



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Container No: S113163



Part: D3043-041

Job No: 181787

Serial No/Batch: S113163

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/24/18

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : <u>18/9/27</u>	Sequence #: _____	QTY Affected : _____		MRB (QSI042) INSP 12 <u>18/9/27</u>	
Description Work Order Deviation Drill vent holes as required to ensure proper welding. Ø0.129 holes, CSK Ø0.225 x 100, 2.0" from end on bottom of step. Plug Plug with MS20601AD4WZ before print.		Disposition Acceptable. See D2546 Rev. C for reference.		Completed By <u>SH</u> 18/9/28 Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: _____			